

Date: Thursday, 2/21/2008 9:26:02 AM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LOCK PLATE		
Job Number	37563			Part Number	D2534		
Estimate Number	10332			Drawing Number	D2534 REV D		
P.O. Number	:			Project Number	N/A		
This Issue	2/21/2008	S.O. No.	:	Drawing Revision	D		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	2/27/2008	Qty:	40
Previous Run	36662			Um:	Each		
Written By	<u>HP 080221</u>						
Checked & Approved By							
Comment	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-06-20 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304S11GA	304/316 .125 Sheet	
		Comment: Qty.: 0.0448 sf(s)/Unit Total : 1.7934 sf(s) 304/316 .125 Sheet (M304S11GA)	
		Batch: <u>104934</u> <u>HB 8-2-25</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2734 Dwg Rev: <u>D</u> <u>HB 8-2-25</u> <u>(53)</u> Prog Rev: <u>D</u>	
		2-Deburr if necessary <u>08/02/26</u> → <u>52 + 1 scrap</u> <u>53</u> <u>DR</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	<u>HB 8-2-25</u> <u>52</u> <u>PD</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	<u>10802-27</u> <u>52</u> <u>cenvtech</u>
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	<u>PC 5/1/27</u> <u>(52)</u>
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2534 PAR #: N/A Fault Category: Prod/Fab. Ass <sup>med & small</sup> NCR:  Yes No DQA: D Date: 06/02/21  
 QA: N/C Closed: H Date: 08/02/21

NCR: <u>37563</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/27	<u>J0</u>	1 part scrap. Part bent when breaking the tab off.	<u>AS1012</u>	- Scrape & destroy - No replace.	<u>SAD</u> <u>AS</u> <u>08/02/27</u>	<u>-</u> <u>08/02/27</u>	<u>AS1012</u>	<u>07/02/21</u>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK PLATE

Job Number: 37563

Part Number: D2534

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(52)

Comment: FINAL INSPECTION/W/O RELEASE

Do 08/02/07

Job Completion



~ 2008/2/27

(52)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37563
Description: Lock Plate	Part Number:	D2534
Inspection Dwg: D2534	Rev: D	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

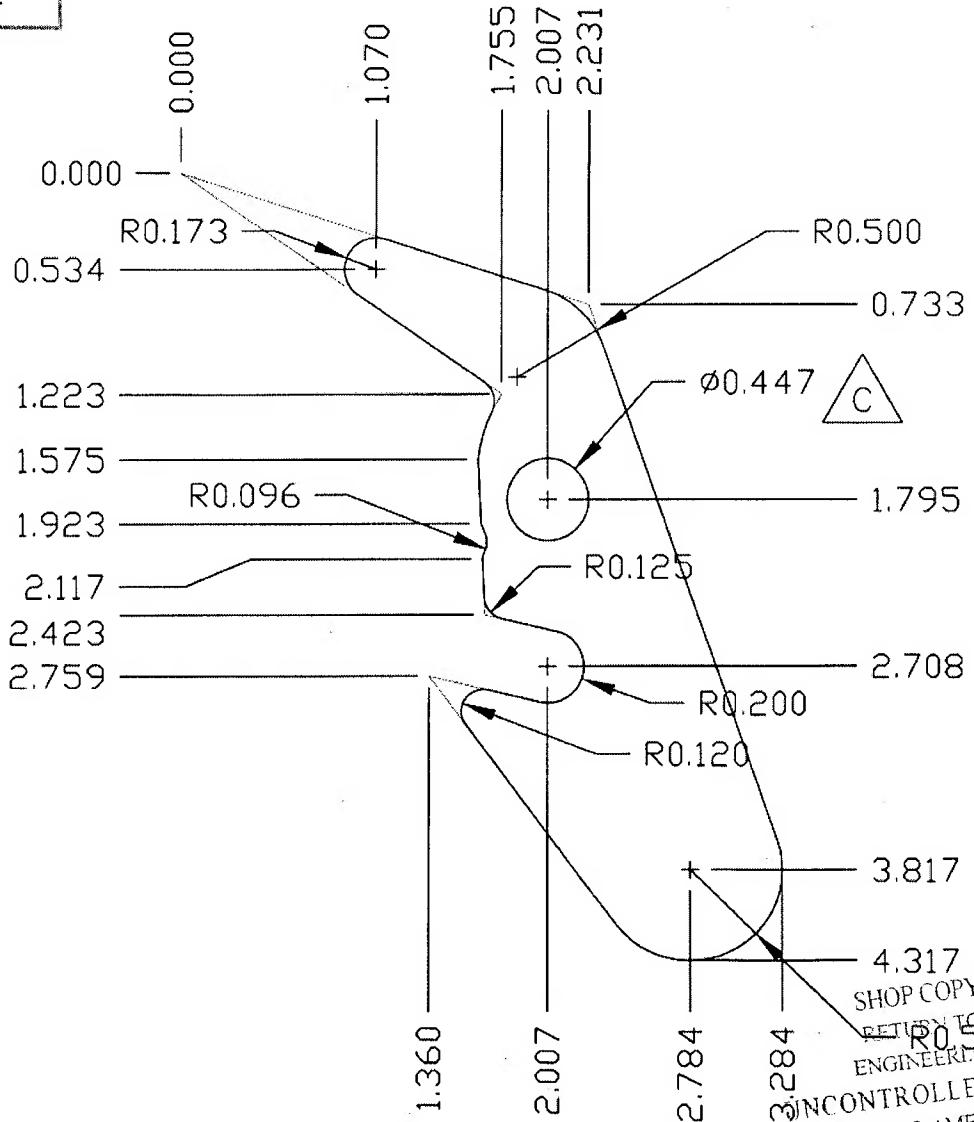
## X First Article      Prototype

Measured by:	<u>b</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	8-2-25	Date:	08/02/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	 

**DART**

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2534	REV. D SHEET 1 OF 1
DATE 04.12.14		TITLE LOCK PLATE	SCALE 1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

**RELEASED**04.12.16 *[Signature]*

4.317  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 37563

D2534 LOCK PLATE

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

